

**Amendments to the Specification:**

Please amend the specification as follows:

*Please insert the following before the paragraph starting on page 1, line 4:*

**BACKGROUND OF THE INVENTION**

*Please replace the paragraph starting at page 1, line 4 with the following:*

The invention relates to an exhaust gas heat exchanger for motor vehicles ~~as claimed in the preamble of patent claim 1, of the same type~~ which is known from commonly assigned DE-A 199 07 163 from the same applicant. The invention also relates to a method for production of an exhaust gas heat exchanger such as this.

*Please replace the paragraph starting at page 1, line 11 with the following:*

DE-A 199 07 163 ~~from the same applicant has disclosed~~ discloses a welded exhaust gas heat exchanger which comprises a housing casing, a pipe or tube bundle and pipe bases (header plates), with the ends of the pipes being welded in the pipe bases and the pipe bases being welded via circumferential beads to the housing casing. The pipe ends are welded in the pipe base at the ends, while the pipe bases are welded circumferentially to the housing casing, that is to say the laser beam which is used for the welding process is directed at right angles to the pipe axes. In this case, the laser beam is either passed around the housing or the laser beam is stationary and the housing is rotated about its longitudinal axis. The different welding directions (with respect to the direction of the laser beam) make it necessary to clamp the workpiece, that is to say the heat exchanger block, ~~in~~ at least twice successively. This increases the production complexity. Furthermore, in the known production method, provision is made for the heat exchanger block, that is to say the housing casing, not to be cut to length until two circumferential weld beads have been applied, to be precise by means of an additional laser beam step. This also involves additional production complexity.

*Please insert the following before the paragraph starting on page 2, line 5:*

**SUMMARY OF THE INVENTION**

*Please replace the paragraph starting at page 2, line 5 with the following:*

This object is achieved by the ~~features of patent claims 1 and 3~~ present invention. According to ~~these claims~~ one embodiment of the present invention, both welded joints can be produced, that is to say the pipe/pipe base joint and the pipe base/housing casing joint, can be produced in a jig for the heat exchanger block, i.e., that is to say effectively in one operation. Both weld beams can be produced from the end face of the heat exchanger block, so that the block needs not be moved in the jig. Furthermore, this avoids the additional process step of cutting the housing casing to length by using the welding tool for cutting, so that the housing casing is cut to length even before the welding process.

*Please insert the following before the paragraph starting on page 3, line 2:*

**BRIEF DESCRIPTION OF THE DRAWINGS**

*Please insert the following before the paragraph starting on page 3, line 18:*

**DETAILED DESCRIPTION OF THE DRAWINGS**

*Please replace the paragraph starting at page 3, line 30 with the following:*

Figure 2 shows the end area 3 from Figure 1 in the form of a longitudinal cross section through the coolant aperture opening 6. The pipe base 7 is inserted into the end area of the housing casing 2 such that it is flush, and thus forms a common end plane 9. Exhaust pipes 10 are inserted into the openings 8 in the pipe base 7, although only some of the pipes 10 from the entire pipe bundle are illustrated. Exhaust gas flows through the inside of these exhaust pipes 10, with coolant flowing around their outside, which coolant is taken, for example, from a coolant circuit (which is not illustrated) for an internal combustion engine in the motor vehicle.

*Please replace the paragraph starting at page 5, line 10 with the following:*

Figure 5 shows the completely assembled block 20' which is held in a clamping apparatus 40 (schematically not shown), arranged, for example, vertically. A laser beam welding apparatus is located above the pipe base 23, that is to say in an end extension of the block 20', and is represented schematically by an ellipse 26. This welding apparatus 26 produces a laser beam 27 which produces the circumferential bead 11 illustrated in Figure 3, that is to say it produces the joint between the pipe base 7 and the housing casing 2 by

moving around the circumference once. The laser beam may in this case be at right angles to, or slightly inclined with respect to, a block axis.